

Work Order ID 63858

November 17, 2010 8:26:47 AM

PRELIMINARY ISSUE

Page 1

Item ID: D3608-1

Accept

Revision ID:

Item Name: Lower Doubler

Start Date: 11/17/10 Start Qty: 1.00

Required Date: 11/17/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3608

PC1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608

Dwg Rev: *PC1*

Prog Rev: *PC1*

2-Deburr if necessary

B10-11-M

(1)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-M

120

QC8- Inspect parts - second check

0.00 - inspect to b PC1



QC

Memo

0.00

Quality Control

Day only
Stability (X)

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Item ID: D3608-1

Accept

Revision ID:

Item Name: Lower Doubler

Setup Start

Stop

Start Date: 11/17/10 Start Qty: 1.00

Required Date: 11/17/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

shg to Eng
Harvey

0.00

u 10.11.17

Packaging

ENG 1106

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10.11.17

RELEASED

AUTH u 10/11/23

DATE 10.11.22

u 10.11.17

Picklist Print

November 17, 2010 8:26:46 AM

Page 1

Work Order ID: 63858

Parent Item: D3608-1

Parent Item Name: Lower Doubler



Start Date: 11/17/10

Required Date: 11/17/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
 10.11.17 as per PC1 dwg DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S20GA | | Purchased | No | | | 100 | sf | 109.3000 | 0.7392 | 0.778105 | | | |



304/316 .040 Sheet



11-10-11-17

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 105.3 | |
| 115762 | 10.2 | |
| 115953 | 95.1 | |
| MAT20 | 4 | |
| 113062 | 1.398 | |
| 115440 | 2.602 | |

115953

①

| | | |
|-----------------------------------|--|----------------------|
| DART AEROSPACE LTD | | Work Order: 63858 |
| Description: Lower Double | | Part Number: D3608-1 |
| Inspection Dwg: D3608-1, Rev: PC1 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

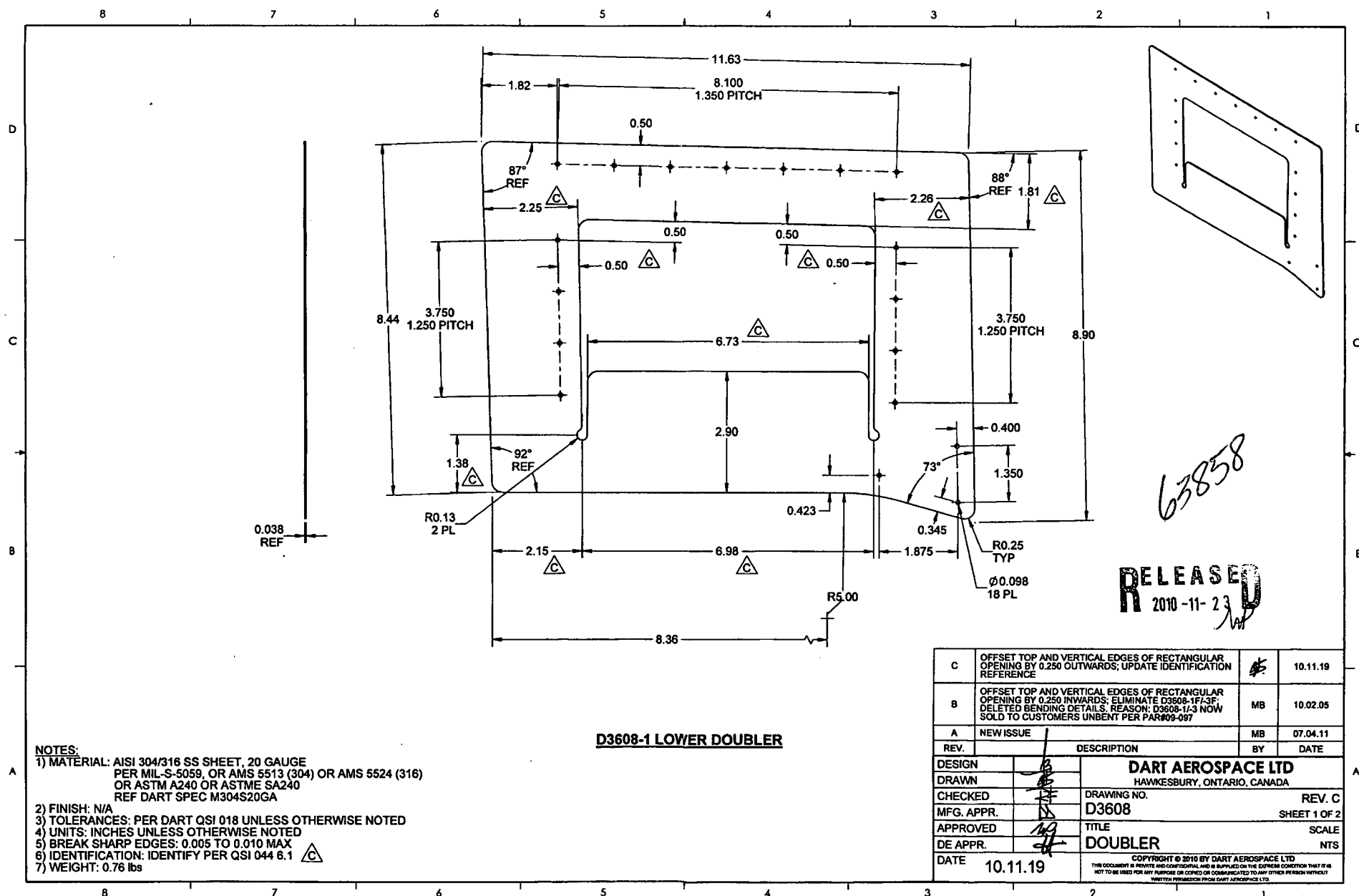
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .098 | + .004 - .001 | .101 | X | | ✓ HB02 | |
| 1.82 | ± .030 | 1.814 | X | | ✓ | |
| 8.100 | ± .010 | 8.094 | X | | ✓ PRO HB02 | |
| 1.380 | ± .010 | 1.343 | X | | ✓ | |
| 11.63 | ± .030 | 11.622 | X | | ✓ PRO HB02 | |
| 2.26 | ± .030 | 2.268 | X | | ✓ | |
| 1.813 | ± .010 | 1.816 | X | | ✓ | |
| .500 | ± .010 | .502 | X | | ✓ | |
| 3.750 | ± .010 | 3.743 | X | | ✓ | |
| 1.250 | ± .010 | 1.242 | X | | ✓ | |
| .400 | ± .010 | .400 | ✓ | | ✓ | |
| 1.350 | ± .010 | 1.342 | X | | ✓ | |
| 8.90 | ± .030 | 8.892 | X | | ✓ PRO HB02 | |
| .345 | ± .010 | .343 | X | | ✓ | |
| 1.875 | ± .010 | 1.875 | X | | ✓ | |
| .423 | ± .010 | .419 | X | | ✓ | |
| 6.980 | ± .010 | 6.980 | X | | ✓ | |
| 2.147 | ± .010 | 2.153 | X | | ✓ | |
| 1.375 | ± .010 | 1.375 | X | | ✓ | |
| 8.44 | ± .030 | 8.432 | X | | ✓ PRO HB02 | |
| 6.730 | ± .010 | 6.735 | X | | ✓ | |
| .038 | ± .010 | .036 | X | | ✓ | |

| |
|-----------------|
| Measured by: JB |
| Date: 10-11-17 |

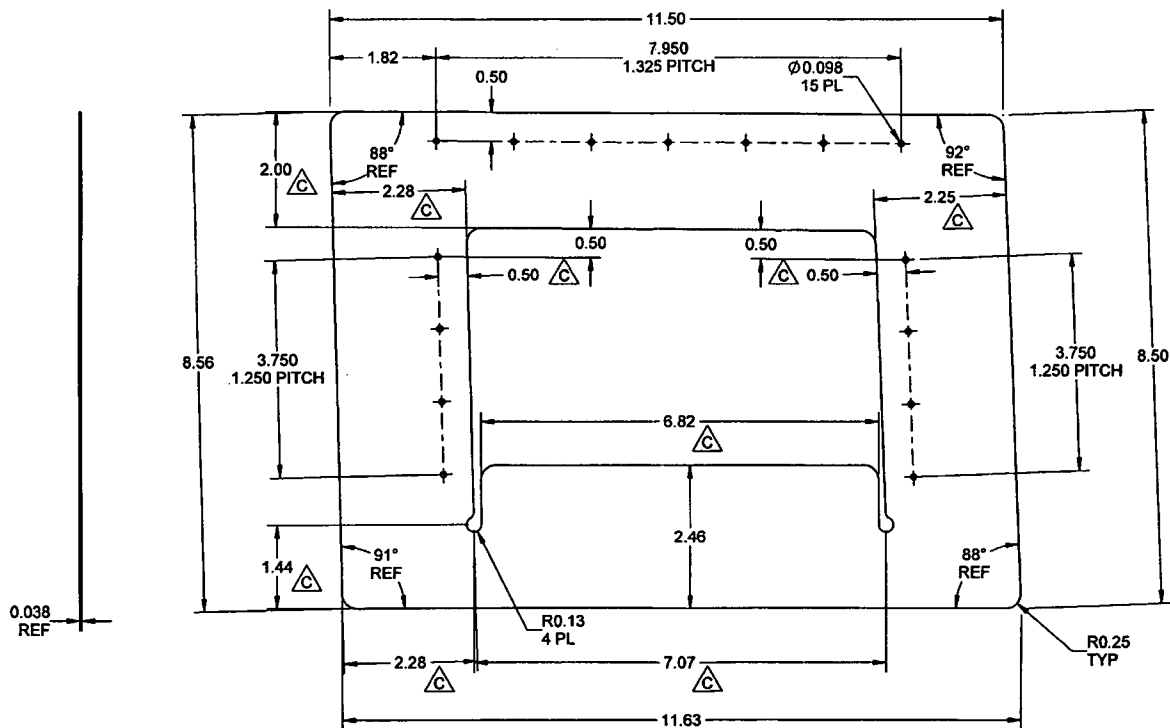
| |
|----------------|
| Audited by: S |
| Date: 10/11/17 |

| |
|---------------------|
| Prototype Approval: |
| Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



RELEASE
2010-11-23



D3608-3 UPPER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.75 lbs

| | | | |
|---|---------------|--|--------------|
| DESIGN | JS | DART AEROSPACE LTD | |
| DRAWN | JS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JS | DRAWING NO. | REV. C |
| MFG. APPR. | JS | D3608 | SHEET 2 OF 2 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | DOUBLER | NTS |
| DATE | 10.11.19 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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63858

RELEASED
2010-11-23
MP